

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007267**Date Inspected:** 02-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huan Wen Pang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 1

SMAW process Tack welding of weld joint #002 located on Cross Beam CB201B-007. Welder is identified as 215326. ZPMC QC is identified as Tian Zei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 – B – u2.

BAY 2

FCAW process welding of weld joint #132 located on SSD10 – PP086. Welder is identified as 204730. ZPMC QC is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2233 – Tc – u4b – f.

BAY 3**Ultrasonic Testing**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Component. The weld designations reviewed are as follows:

WELDING INSPECTION REPORT

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1. FB005 – 046 – 044
2. FB010 – 037 – 043

Green Tags

Issued green tags after the completion of NDT requirements for the following OBG components:

FB010 - 037 – Green Tag # 009035

FB010 - 039 – Green Tag # 009036

FB005 - 046 – Green Tag # 009004

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #011 located on Longitudinal Diaphragm LD003 – 040. Welder is identified as 067947. ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 - 3.

FCAW process welding of weld joint #012 located on Floor Beam FB011 – 034. Welder is identified as 208035. ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 - 3.

BAY 5

This QA Inspector observed the following work not in compliance:

During random in-process visual inspection on Traveler Rail (TR14 – PP21 – 001), observed that single pass fillet weld size is 11mm, which is not as per the Welding Procedure Specification # WPS – B – T – 2131, where the maximum fillet weld size is 7mm. Besides this, also observed that Traveler Rail (TR14 – PP21 – 001/002), does not comply with the approved drawing. According to the approved drawing, it requires 8mm fillet weld both side while ZPMC welded all around.

For further details, please see Incident reports (04-0120F4_TL015_B227_06-02-09.Fillet weld size)and(040120F4_TL015_B227_06-02-09_Fillet weld all around).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep
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Quality Assurance Inspector

Reviewed By:	Prue,Erik
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QA Reviewer
